

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
	/							

NOTE: Date & initial all entries

Work Order ID: 64795

Friday, December 17, 2010 7:56:13 AM



Page 2

Item ID: D3293-1

Accept



Setup Start



Revision ID:

Item Name: Doubler

Stop



Start Date: 12/16/2010 Start Qty: 10.00



Cust Item ID:

Required Date: 1/19/2011 Req'd Qty: 10.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop


**Sequence ID/
Work Center ID**

130



Small Fab

Small Fab

**Operation
Description**

Small Fab

Memo

1- Deburr

**Set Up/
Run Hours**

0.00

Tool ID
Tool #
**Plan
Code**
**Accept
Qty**
**Reject
Qty**
**Reject
Number**
**Insp.
Stamp**

140



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

0.00

0.00

150



HandFinish

Hand Finishing

Chemical Conversion Coat per QSI005 4.1

0.00

=> NJ

110210

0.00

X12 Q

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Page 3

Item ID: D3293-1

Accept



Setup Start



Revision ID:

Item Name: Doubler

Stop



Start Date: 12/16/2010 Start Qty: 10.00



Cust Item ID:

Required Date: 1/19/2011 Req'd Qty: 10.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

160



Powdercoat

Powder Coating

Operation
Description

Black Sandtex(Ref:4.3.5.7) per QSI005 4.3

Set Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberReject
StampInsp.
Stamp

M 112588

Memo

0.00

12. BL 11-02-8.

START TIME:

10.20

OVEN TEMPERATURE:

FINISH TIME:

10.50

170



QC

Quality Control

QC3- Inspect Part Finish

0.00

12 d M 110202

Memo

0.00

180



Packaging

Packaging

Identify as per dwg & Stock Location: 211

0.00

Memo

0.00

11/28/12

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Work Order ID 64795

Friday, December 17, 2010 7:56:13 AM



Page 4

Item ID: D3293-1

Revision ID:

Item Name: Doubler

Start Date: 12/16/2010 Start Qty: 10.00

Accept



Setup Start



Required Date: 1/19/2011 Req'd Qty: 10.00



Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memos

0.00

MF
11-02-08

W/O:		WORK ORDER CHANGES					
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Picklist Print

Friday, December 17, 2010 7:56:17 AM

Page 1

Work Order ID: 64795



Parent Item: D3293-1



Parent Item Name: Doubler

Start Date: 12/16/2010

Required Date: 1/19/2011

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP: A 04.08.24 New issue KJ/JLM
IPP Rev:B Now on Waterjet 06-11-02 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M2024T3S.080		Purchased		No		100	sf	88.0000	1.8264	19.22526			

2024-T3 .080 sheet



Location	Loc Qty	Loc Code
MAT22	88	
104921	2	
105411	7	
112331	3	
113796	9.7	
114025	66.3	

116664

116664

(17)

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DART AEROSPACE LTD	Work Order:	64795
Description: Doubler	Part Number:	D3293-1
Inspection Dwg: D3293	Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by: <u>B</u>	Audited by: <u>S</u>	Prototype Approval:	N/A
Date: 11-3-4	Date: 11/02/02	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.08.24	New Issue	KJ/JLM	
B	08.10.09	0.080 dimension added	KJ/DD	

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D3293-1 DOUBLER

MAKE PER DRAWING FILE "D3293-A1.DWG"

CHECK PER TEMPLATE D3293-1T1

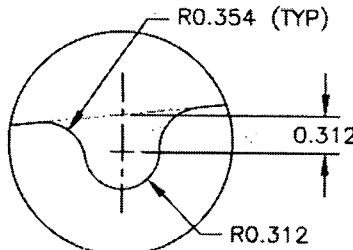
DIMENSIONS SHOWN FOR REFERENCE ONLY

MATERIAL: 2024-T3 (QQ-A-250/4) SHEET 0.080 THICK

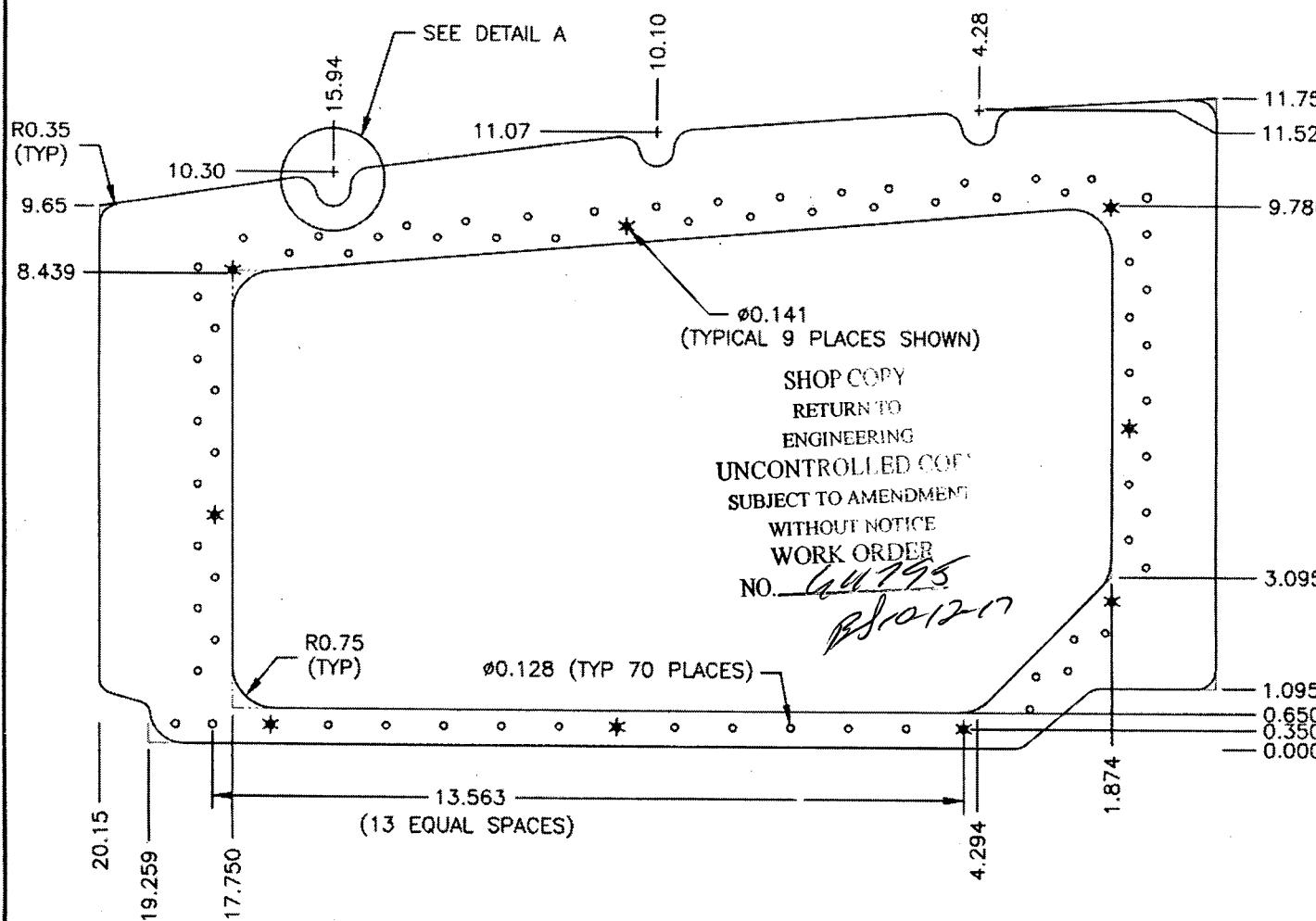
FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1

POWDER COAT BLACK SANTEX (REF. 4.3.5.7) PER
DART QSI 005 4.3

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



RELEASED
4/27/04



DART

NO COPY
SHEET 1 OF 1

DESIGN	DRAWN BY	DART AEROSPACE LTD
		HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO.
		D3293
DATE		SHEET 1 OF 1
04.06.28		SCALE
A	04.06.28	1:3
		TITLE
		DOUBLER
		NEW ISSUE

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